

Work Order ID 72413

Monday, July 25, 2011 11:30:58 AM

Page 1

Item ID: D3836-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/25/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: M114649

6- grind weld flush where indicated on dwg

Pl 11-08-23

②

PMB 11/08/23

SAM 11-08-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Monday, July 25, 2011 11:30:59 AM



Accept



Setup Start



Stop



Start Date: 7/25/2011 **Start Qty:** 2.00

**Cust Item ID:**

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



QC

Memo

0.00

Quality Control

0.00



OC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location:



Packaging

Memo

0.00

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 72413

Monday, July 25, 2011 11:30:59 AM



Page 3

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24

11-08-24

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 11:31:05 AM

Page 1

Work Order ID: 72413

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 7/25/2011


Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2327-3  Spacer Bushing | | Manufactured | No | | | 100 | Each | 16.0000 | 1 | 2 | | | |
|--|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|

Location **72296**
WA
na p/us **71971**

Loc Qty

Loc Code

16

16

M304TS0.750W.065

Purchased

No

100

f

554.2282

1.7808

3.749053



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT018

77.6987

117636

77.6987

WA

441.0436

118181

441.0436

WA007

35.4858906

116267

28.893172

116763

6.5927186

1

1

3.749053

SAD

11-08-16

1.8746

~~3.749053~~

1.8746

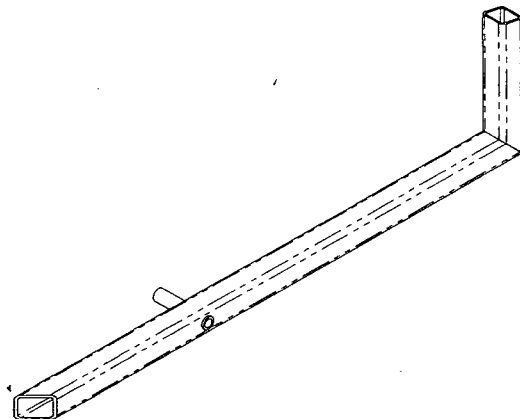
| W/O: | | WORK ORDER CHANGES | | | | | |
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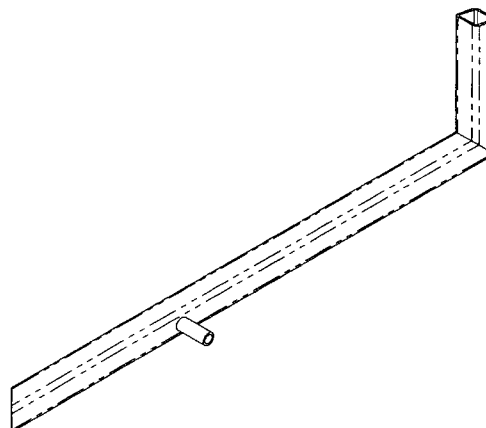
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.99 lbs EACH
 8) WELD PER DART QSI 004

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 2 | | X | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 3 | 1 | 1 | D2327-3 | SPACER BUSHING |
| 4 | 1 | | D3836-1 | RIB |
| 5 | | 1 | D3836-2 | RIB |
| 6 | 1 | 1 | D3836-3 | RIB |

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 72413

11-07-28

RELEASED
08/11/18 MB

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | MB | 08.09.24 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.09.24 | | |

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3836** REV. A

TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

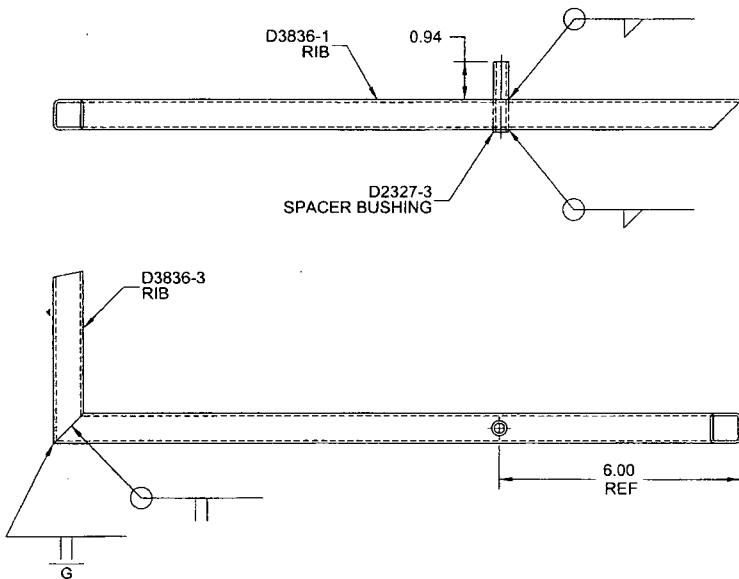
8 7 6 5 4 3 2 1

D

C

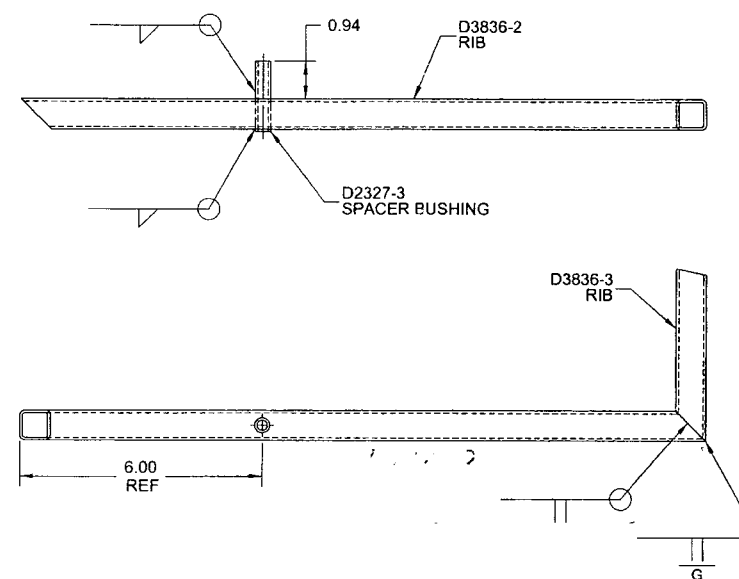
B

A



D3836-041 RIB ASSY (BASKET LID, LH)

12413



D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
08/11/18

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 11/53 | DRAWING NO. D3836 | REV. A |
| MFG. APPR. | | | SHEET 2 OF 3 |
| APPROVED | 11/53 | TITLE RIB ASSY (BASKET LID) | SCALE |
| DE APPR. | | | NTS |
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8 7 6 5 4 3 2 1

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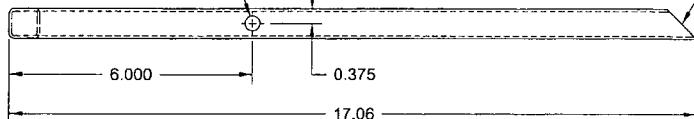
NOTE: Date & initial all entries

0.75 X 45°
CHAMFER

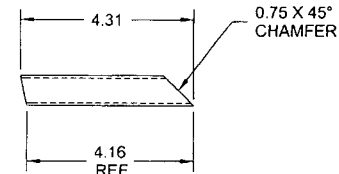


$\phi 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER

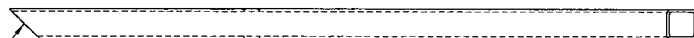


D3836-1 RIB



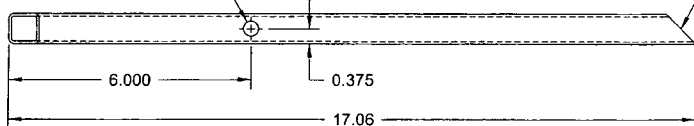
D3836-3 RIB

0.75 X 45°
CHAMFER

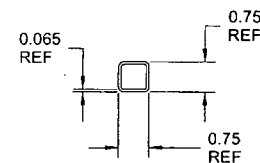


$\phi 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/08

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

| | | | |
|------------|------------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>ASS</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>MP</i> | D3836 | SHEET 3 OF 3 |
| APPROVED | <i>SH</i> | TITLE | SCALE |
| DE APPR. | | RIB ASSY (BASKET LID) | NTS |
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